



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3719

Job Sheet 191685



Part No: 646.3719

Job Qty: 20 pcs

Part Name: Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/6/19

Job Tracking No:

Due Date: 4/2/19

Created By: Marie Lajeunesse

Type: Stock *SOLD*

Description:

Note: DWG REV A SHEET 9 IPP REV:A 12.10.22 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	20 pcs	4/2/19	4/2/19	0.01	0.59	Waterjet - Flow		<i>dc 19/04/02</i>
120	QC 2	20 pcs	4/2/19	4/2/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		<i>dc 19/04/02</i>
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		



Container No: S169110



Part: 646.3719

Job No: 191685

Serial No/Batch: S169110

Revision:

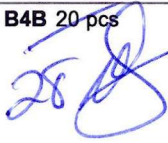
Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/07/19

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

130 QC 8	20 pcs	4/2/19	0.00 0.00	QC 2 - 64	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
140 Outsource - 4 - Anodize	20 pcs	4/2/19		ATG001-VC	5
150 Packaging 2-1 - Receive - B4B	20 pcs	4/2/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	

DAS

APR 03 2019 40

04/24/2019 9-8

MAY 07 2019

PL

160 QC 6	20 pcs	4/2/19	0.00 0.00	Packaging 2 - 36 - B4B	
				QC 6 - 42	
				QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
190 Packaging 3-1 - Stock - B4B	20 pcs	4/2/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				200 QC 21 - SA	20 pcs
QC 21 - SA - 70					
QC 21 - SA - 53					

Part Op 110 - (Waterjet - Flow) 1-Cut as per Dwg

Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O H8043263 ATG, balck anodize and prime as per dwg 646.3719 Rev. A

150 - (Receive & Inspect for Damage & Mat'l Certs)

160 - (QC6- All purchased or subcontracted products)

190 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

200 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	.5556 sf (.02778 ea)	110-Waterjet - Flow - 1	S152151

Job Allocations					
Operation 110-Waterjet - Flow - 1	Component Part M6061T6S.063	Required 1	Inventory 258	Allocated 0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.209inches + 0.005 - 0.001	0.214 0.208	Diameter	0.213
2	Doubler	2.000inches ± 0.030	2.030 1.970		2.003
3	Doubler	2.000inches ± 0.030	2.030 1.970		1.998

Plex 3/6/19 11:13 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART
AEROSPACE

DART Aerospace Ltd.
1270 Alwarden Street
Newkensbury, ON R5A 1K7
CANADA
TEL.: 1 813 632-8200
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www.dartaerospace.com

Container No: S169110

Part: 646.3719

Job No: 191685

Serial No/Batch: S169110

Revision:

Inspector:

Exp Date:

Instructions:

Date: 04/03/19



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043283



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043283

PO Date: 4/24/19

Due Date: 5/3/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	193553	D4703-043	Lock Pin Base : Various STC's Issue P/O to ATG: -HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 3 CLASS 2 -As Per Dwg D4703 -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	5/3/19	6 pcs	0 pcs	6 pcs	\$3.18/pcs	\$19.08
2	R192331	D4842-3	Lower Cutter Body, LH Outsource process-Anodize per QSI017 4.1.10.1 - Issue P/O to ATG : 1- Black Anodize as per Dwg D4842	Firmed	-	5/3/19	4 pcs	0 pcs	4 pcs	\$10.73/pcs	\$42.92



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Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	191686	646.3810	Bracket Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required	Firmed	-	5/3/19	16 pcs	0 pcs	16 pcs	\$7.03/pcs	\$112.48
4	191990	646.3812	Gusset Bracket Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required	Firmed	-	5/3/19	30 pcs	0 pcs	30 pcs	\$6.58/pcs	\$197.40
5	192010	646.3313	Upper Guide Issue P/O to ATG : Hard Anodize Color Black and Prime as per DWG 646.3300	Firmed	-	5/3/19	12 pcs	0 pcs	12 pcs	\$13.58/pcs	\$162.96
6	192599	D4823-1	Upper Cutter Deflector : Various STC's Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg D4823	Firmed	-	5/3/19	6 pcs	0 pcs	6 pcs	\$11.63/pcs	\$69.78



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Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
7	191683	646.3715	Strut Doubler Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.3700	Firmed	-	5/3/19	28 pcs	0 pcs	28 pcs	\$6.73/pcs	\$188.44
						MAY 07 2019					
8	190115	646.3811	Radius Block Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.3, PRIME CARDINAL 7760- 4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required	Firmed	-	5/3/19	12 pcs	0 pcs	12 pcs	\$7.03/pcs	\$84.36
						MAY 07 2019					
9	192398	D4838-1	Upper Cutter Body, LH : Various STC's Issue P/O: _____ ATG, Hard Black Anodize and Prime as per Dwg D4838-1 Rev. A	Firmed	-	5/3/19	8 pcs	0 pcs	8 pcs	\$10.73/pcs	\$85.84
						MAY 07 2019					
10	192396	D4823-1	Upper Cutter Deflector : Various STC's Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg D4823	Firmed	-	5/3/19	2 pcs	0 pcs	2 pcs	\$11.63/pcs	\$23.26
11	192399	D4838-2	Upper Cutter Body, RH : Various STC's Issue P/O: _____ ATG, black anodize and prime as per dwg D4838-2 Rev. A	Firmed	-	5/3/19	8 pcs	0 pcs	8 pcs	\$10.73/pcs	\$85.84
						MAY 07 2019					
12	192006	646.3718	Custom Washer (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O _____ ATG, black anodize and prime as per dwg 646.3718 Rev. A	Firmed	-	5/3/19	21 pcs	0 pcs	21 pcs	\$4.43/pcs	\$93.03
						MAY 07 2019					

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PURCHASE ORDER

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Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
13	192007	646.3010	LH Half Outsource4 (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 646.3000	Firmed	-	5/3/19	10 pcs	0 pcs	10 pcs	\$10.73/pcs	\$107.30
							10 x MAY 07 2019				
14	192008	646.3310	LH Half - Upper Cutter Assembly (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG : 1- Black Anodize as per Dwg 646.3300	Firmed	-	5/3/19	10 pcs	0 pcs	10 pcs	\$18.58/pcs	\$185.80
							10 x MAY 07 2019				
15	190731	646.2910	Deflector (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG : Hard Anodize, Color Black / Prime As per Dwg 646.2900 Rev. N/C	Firmed	-	5/3/19	16 pcs	0 pcs	16 pcs	\$48.48/pcs	\$775.68
16	191991	646.3813	AS350 Strut Bracket Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required	Firmed	-	5/3/19	25 pcs	0 pcs	25 pcs	\$6.58/pcs	\$164.50
							25 x MAY 07 2019				
17	192009	646.3311	RH Half - Upper Cutter Assembly Outsource4 (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG :	Firmed	-	5/3/19	10 pcs	0 pcs	10 pcs	\$18.58/pcs	\$185.80
							10 x MAY 07 2019				
18	191986	646.3610	Filler Issue P/O to ATG : 1- Hard Anodize Black and Prime as per Dwg 646.3600	Firmed	-	5/3/19	24 pcs	0 pcs	24 pcs	\$6.60/pcs	\$158.40
							24 x MAY 07 2019				

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K6A 1K7
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PURCHASE ORDER

POHB043283



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
19	191684	646.3716	Gauge Bracket (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG : <i>21 X</i>	Firmed	-	5/3/19	20 pcs	0 pcs	20 pcs	\$6.15/pcs	\$123.00
						<i>MAY 07 2019</i>					
20	191685	646.3719	Doubler (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O <i>28 X</i> ATG, balck anodize and prime as per dwg 646.3719 Rev. A	Firmed	-	5/3/19	28 pcs	0 pcs	28 pcs	\$6.25/pcs	\$175.00
						<i>MAY 07 2019</i>					
21	190724	647.2113	Lower Rail, U-Channel (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG : 1- Black Anodize as per Dwg 647.2100 2- PRIME AS PER DWG, SEE NOTE #2	Firmed	-	5/3/19	12 pcs	0 pcs	12 pcs	\$11.60/pcs	\$139.20
Grand Total:										\$3,180.07	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 917756

Date: 03-May-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
21 ea	Part: 646.3718 Custom Washer Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 24987 PO: POHB043283		Rev: A Line: 12
25 ea	Part: 646.3813 AS350 Strut Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 24991 PO: POHB043283		Rev: A Line: 16
28 ea	Part: 646.3719 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 24995 PO: POHB043283		Rev: A Line: 20
12 ea	Part: 646.3811 Radius Block Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied),		Rev: A
Made in Canada.			

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MAY 06 2019
DART AEROSPACE LTD.

RECEIVED

MAY 06 2019

DART AEROSPACE LTD.



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 917756

Date: 03-May-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	.0006-.0009" (.6 - .9 mils) per drawing. Job: 24983 PO: POHB043283 ✓ Line: 8		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>MAY 03 2019</u> Certified Signature: <u></u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
DAS 40 9-89			
Made in Canada.			